

**Work Order ID 67282**

Tuesday, March 15, 2011 7:04:27 AM



Page 1

Item ID: D3196-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bar

Start Date: 3/15/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 3/16/2011 Req'd Qty: 2.00



Customer:

Reference: *11-03-15*

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3196    | Rev C        |

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: (0.75" x 1.50") x 26.200" long Bar

*conf 11/03/15**2* *0*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine D3196-1 as per Folio FA339 and Dwg D3196-1 □ 2-  
Deburr*conf 11/03/16**2* *0*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*conf 11/03/16**2* *0*

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Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

| Sequence ID/<br>Work Center ID          | Operation<br>Description  | Set Up/<br>Run Hours | Tool ID | Tool #       | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|---|---|----------------------|---------|--------------|--------------|---------------|---------------|------------------|----------------|
| 130<br><br>QC<br>Quality Control        | QC8- Inspect parts - second check<br><br>Memo   | 0.00<br><br>0.00     |         | H.A 11/03/16 |              | 2             | 0             |                  |                |
| 140<br><br>HandFinish<br>Hand Finishing | Chemical Conversion Coat per QSI005 4.1<br><br>Memo   | 0.00<br><br>0.00     |         |              |              | 2             |               | BR 11-3-16       |                |
| 150<br><br>Powdercoat<br>Powder Coating | Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3<br>M 115128.<br>Memo<br>START TIME: 11:25<br>320° FINISH TIME: 11:55 | 0.00<br><br>0.00     |         |              |              | 2             |               | BR 11-3-17       |                |

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Item ID: D3196-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bar

Start Date: 3/15/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 3/16/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

| Sequence ID/<br>Work Center ID    | Operation<br>Description                                    | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|-----------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160<br><br>QC<br>Quality Control  | QC3- Inspect Part Finish<br><br>Memo                        | 0.00<br><br>0.00     |         |        |              | 2             | 6             | 11/03/17         |                |
| 170<br><br>Packaging<br>Packaging | Identify as per dwg & Stock Location <u>268</u><br><br>Memo | 0.00<br><br>0.00     |         |        |              |               | 11/3/17       | 2x24             |                |
| 180<br><br>QC<br>Quality Control  | QC21- Final Inspection - Work Order Release<br><br>Memo     | 0.00<br><br>0.00     |         |        |              |               |               | 11/3/18          |                |

11-03-17  
2

# Picklist Print

Tuesday, March 15, 2011 7:04:24 AM

Page 1

Work Order ID: 67282



Parent Item: D3196-1



Parent Item Name: Bar

Start Date: 3/15/2011

Required Date: 3/16/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev: A New Issue 05-11-08 JLM

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6B0.750X01.50<br>0        |                        | Purchased     | No          |                     |                  | 100             | f                  | 65.5577        | 2.183       | 4.595789     |               |                |        |



6061-T6 Bar .750 X 1.50

Location

Loc Qty

Loc Code

MAT

65.5577

116405

14.8524

116604

2.7053

→ 116623

48

4.595 enr 11/03/15

|                       |        |              |         |
|-----------------------|--------|--------------|---------|
| DART AEROSPACE LTD    |        | Work Order:  | 67287   |
| Description: Bar      |        | Part Number: | D3196-1 |
| Inspection Dwg: D3196 | Rev: C | Page 1 of 1  |         |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance            | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|----------------------|------------------|--------|--------|----------------------|----------|
| 26.094            | +/-0.010             | 26.094           | —      |        | M-type HL-2          |          |
| 4.045             | +/-0.010             | 4.046            | —      |        | Vern HL-7            |          |
| 18.003            | +/-0.005             | 18.003           | —      |        | M-type HL-2          |          |
| 0.750             | +/-0.005             | .750             | —      |        | Vern HL-7            |          |
| 1.500             | +/-0.010             | 1.502            | —      |        | "                    |          |
| Ø0.344            | +0.006/-0.001        | Ø.344            | —      |        | "                    |          |
| Ø0.660 x 100°     | +0.008/-0.001 x 0.5° | Ø.664 x 100°     | —      |        | "                    |          |
| 0.060 x 45°       | +/-0.010 x 0.5°      | Ø.066 x 45°      | —      |        | "                    |          |
| 0.750             | +/-0.010             | .754             | —      |        | "                    |          |
| 0.250             | +/-0.010             | .253             | —      |        | "                    |          |
| 3.495             | +/-0.010             | 3.495            | —      |        | "                    |          |
| 9.000             | +/-0.010             | 9.000            | —      |        | M-type HL-2          |          |
| 16.844            | +/-0.010             | 16.844           | —      |        | "                    |          |
| 21.498            | +/-0.010             | 21.498           | —      |        | "                    |          |
| R0.125            | +/-0.010             | R.125            | —      |        | Rad-gage             |          |
| 1.1 00            | +/-0.010             | 1.090            | —      |        | Vern HL-7            |          |
| R0.125            | +/-0.010             | R.125            | —      |        | Rad-gage             |          |
| 0.444             | +/-0.010             | .440             | —      |        | Vern HL-7            |          |
|                   |                      |                  |        |        |                      |          |
|                   |                      |                  |        |        |                      |          |
|                   |                      |                  |        |        |                      |          |
|                   |                      |                  |        |        |                      |          |
|                   |                      |                  |        |        |                      |          |

|              |          |             |          |                     |     |
|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | aml      | Audited by: | B.A      | Prototype Approval: | N/A |
| Date:        | 11/03/16 | Date:       | 11/03/16 | Date:               | N/A |

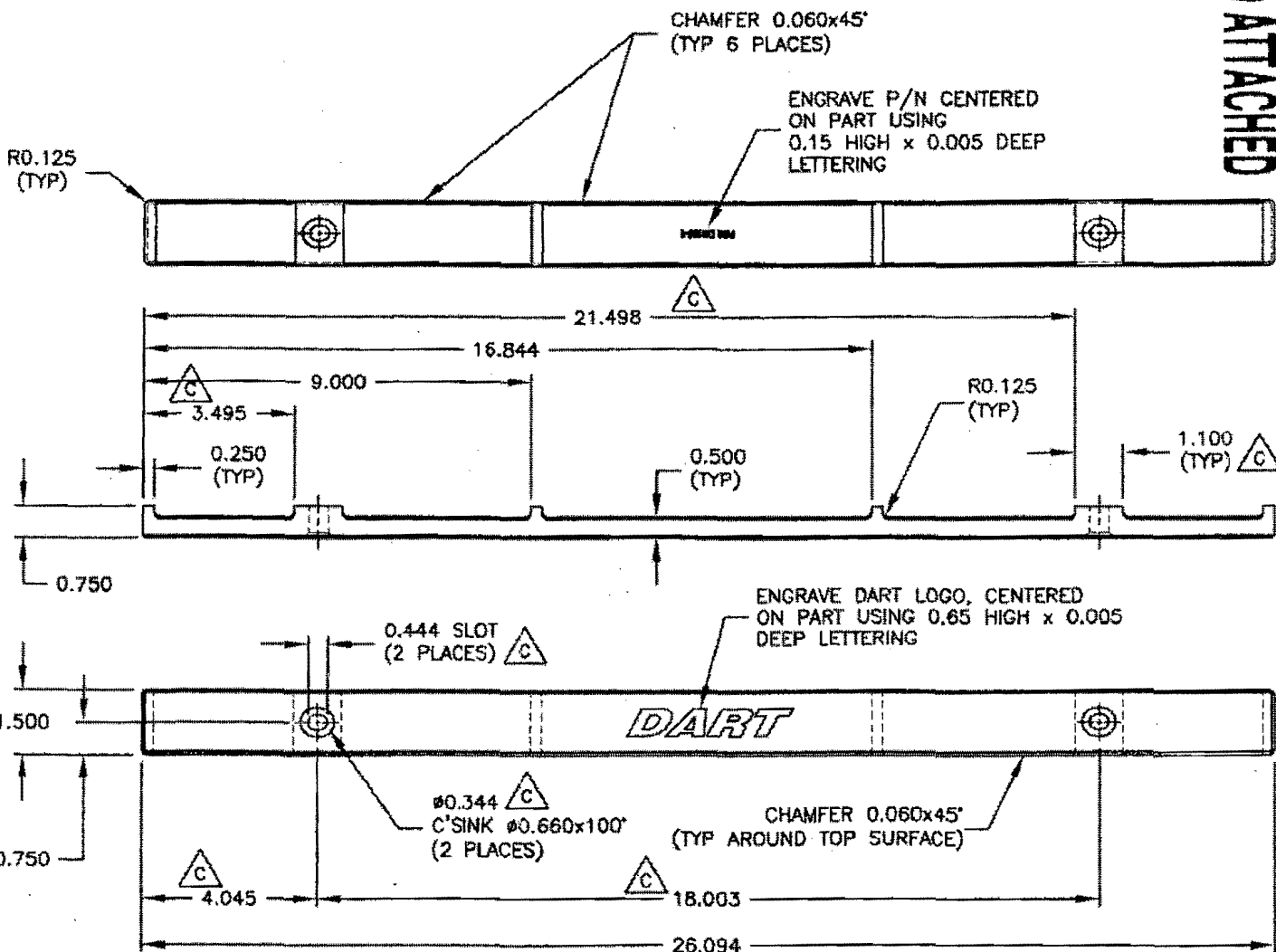
| Rev | Date     | Change                            | Revised by | Approved |
|-----|----------|-----------------------------------|------------|----------|
| A   | 04.04.20 | New Issue                         | KJ/RF      |          |
| B   | 06.10.24 | Dwg Rev. updated                  | KJ/JLM     |          |
| C   | 07.03.21 | Dimensions updated per Dwg rev. C | KJ/JLM     | FE       |

**DART**

RELEASED

06.10.31

DEO ATTACHED



**D3196-1 BAR**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8) (REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

| DESIGN            | DRAWN BY           | DART AEROSPACE LTD          |
|-------------------|--------------------|-----------------------------|
| CHECKED <i>PH</i> | APPROVED <i>PH</i> | HAWKESBURY, ONTARIO, CANADA |
| DATE 06.10.31     | TITLE BAR          | REV. C                      |
| A                 | 03.06.25           | NEW ISSUE                   |
| B                 | 06.09.25           | ADD D3196-5                 |
| C                 | 06.10.31           | ADD SLOTS ON -1; REMOVED -5 |
| SHEET 1 OF 3      |                    | SCALE 1:4                   |

w/067282